

Date: Monday, 2/11/2008 2:12:12 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 37339
 Estimate Number : 11668
 P.O. Number :
 This Issue : 2/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2845
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2845 REV A
 Previous Run : 36089 Drawing Revision : A
 Material :
 Due Date : 2/18/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : KA 08 02 11
 Comment : Est: B 00.11.01 Removed P/O for Powder Coat - in house
 processEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.6109 f(s)/Unit Total: 32.2182 f(s)

304 RD Tube .500 x .035W

M304TR0500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 17.11" long (Hole ctr. to hole ctr.) using

Jig DT 8012*

Batch M 107098 (13)

M 106593 (8)

88 08/02/12 (20)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Form per Dwg D2845 using brake and bending Jig DT 8238-C

Deburr

D 08/02/12 (20)

DAD 08/02/17

20

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/15 (20)

4.0 POWDER COATING POWDER COATING



M 107085



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3.

FX 08/02/19 (20)

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-19

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 28/02/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 37339

Part Number: D2845

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 265

8/2/19 SP (20)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

2008/2/22

Job Completion



2008/2/20

(20)

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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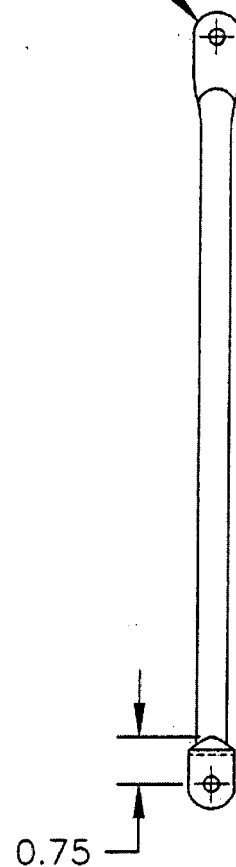
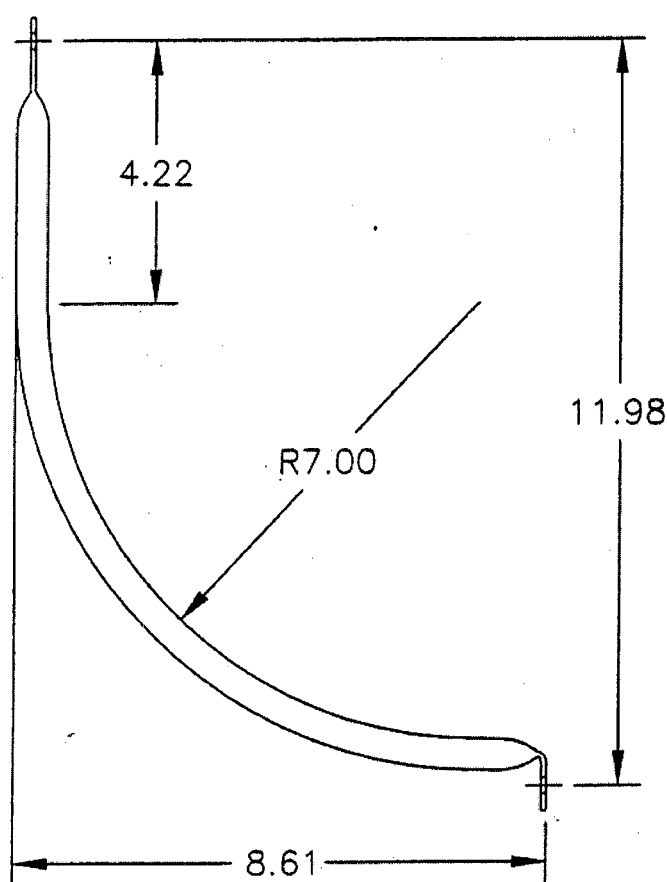
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>PH</i>	APPROVED <i>CS</i>	DRAWING NO. D2845	REV. A SHEET 1 OF 1
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37339

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3